

Date: Tuesday, 10/17/2006 11:21:31 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|-----------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : GAS SPRING ASSEMBLY |
| Job Number | : 29047 | | |
| Estimate Number | : 10181 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D2153 |
| This Issue | : 10/17/2006 S.O. No. : <i>N/A</i> | Drawing Number | : D2153 REV. A1 |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : PURCHASED/PARTS | Drawing Revision | : A1 |
| Previous Run | : 26155 | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 10/30/2006 |
| Checked & Approved By | : <i>[Signature]</i> | Qty: | <i>108</i> Um: Each |
| Comment | : Est: E 02.07.08 Re-format KJ/RF | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *2261**C206110117 (108)*

Gas Spring P/N: SL13-10 (10lb)

Possible supplier: Spring Lift Corporation *attwood*

Note: Do not ship by air**

Allow an extra 7 to 10 business days for shipping**

Material release note is required

2.0

D2153P

Door Prop



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)
 GAS SPRING ASSEMBLY

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

206110117 108

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect Test Spring is 10lb

206-10-24 108

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Drawing Name: GAS SPRING ASSEMBLY

Job Number: 29047

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30153

Lock Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Lock Nut

214

Pick:

Qty Part Number

Description

Batch

2 D3015-3

Lock nut

328706

6.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

216

Pick:

Qty Part Number

Description

Batch

2 AN960JD516

Washer

M101369 79

M102328 137

7.0

SL69BS

Ball Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Ball Stud

Pick:

Qty Part Number

Description

Batch

2 SL69-BS

Stud

M102458 120

M10036986

06/10/25 (108)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2153

2- Remove Spring Lift name and address with Acetone, leave only warning:

"DO NOT OPEN HIGH PRESSURE"

06/10/25 (108)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-10-25 (108)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST218

06/10/26 (108)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: RP Date: 6/15/28
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

Job Number: 29047

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



108

Comment: FINAL INSPECTION/W/O RELEASE

19 06/10/26

Job Completion



u 06.10.26

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

attwood**SWIVLEZE**

TELEPHONE: 512-897-2290

CUST: 68580 MST: 36442-00

~~CCH/EEET~~

PP/A

BILL TO: DART AERO LTD.
REQ: 10/18/06PRO NO: 442 99800
SHIP VIA: UPS GROUND
BOL: 00226970000312457

FREIGHT: _____

F ATTWOOD / SWIVL-EZE

R

O 1016 NORTH MONROE

M LOVELL

MI 49331-0240

T DART AERO LTD,
O 1270 ABERDEEN STREET

HANKSBURY

ON

K6A 1K7

CPTS:

1 X

PO#: 2261

NGT:

42

DATE: 10/18/06

SFUR: 8

LABEL NO:
40926600C

---ROUTING GUIDE INFO---

---SHIPPED---

| CPTS | QTY | LOCATN | UM | PART# | UPC | DESCRIPTION / SKD | LINE QTY | ORDER |
|------|-------|--------|----|-----------|-----|--------------------------|----------|-------|
| 3 | 108 ✓ | Z09211 | EA | SL13-10-1 | ✓ | SS SPRNG 15" EXTC 10# BL | 1 | 108 |
| 2 | 200 | Z10321 | EA | SL69-B5-1 | | 10MM BALL STUD N/THRD | 2 | 200 |



===== COMPLETE =====

PICK BY: _____

PAGE: 1 (ONLY PAGE)